

NIR-14-7724



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RBW895-3101-04-145**Job Sheet 199269****Part No:** RBW895-3101-04-145**Job Qty:** 1 pcs**Part Name:** Main Rotor Blade Tab Bender**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/15/19**Job Tracking No:****Due Date:** 10/16/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBW895-3101-04-145 Rev A IPP Rev. A 19.08.15 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	10/16/19		0.00	0.50	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	10/16/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/16/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S223773**Part:** RBW895-3101-04-145**Job No:** 199269**Serial No/Batch:** S223773**Revision:** A**Inspector:****Exp Date:****Instructions:**

Date: 10/18/19

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OCT 21 2019

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P.T.O.

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	10/16/19	0.00 0.00	
				QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

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Part Op 110 - (Small Fab) 1-Assemble as per DWG. 2-Apply LOCTITE 262 between surface of item -07 and item -03 and remove Descriptions: excess.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____) The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

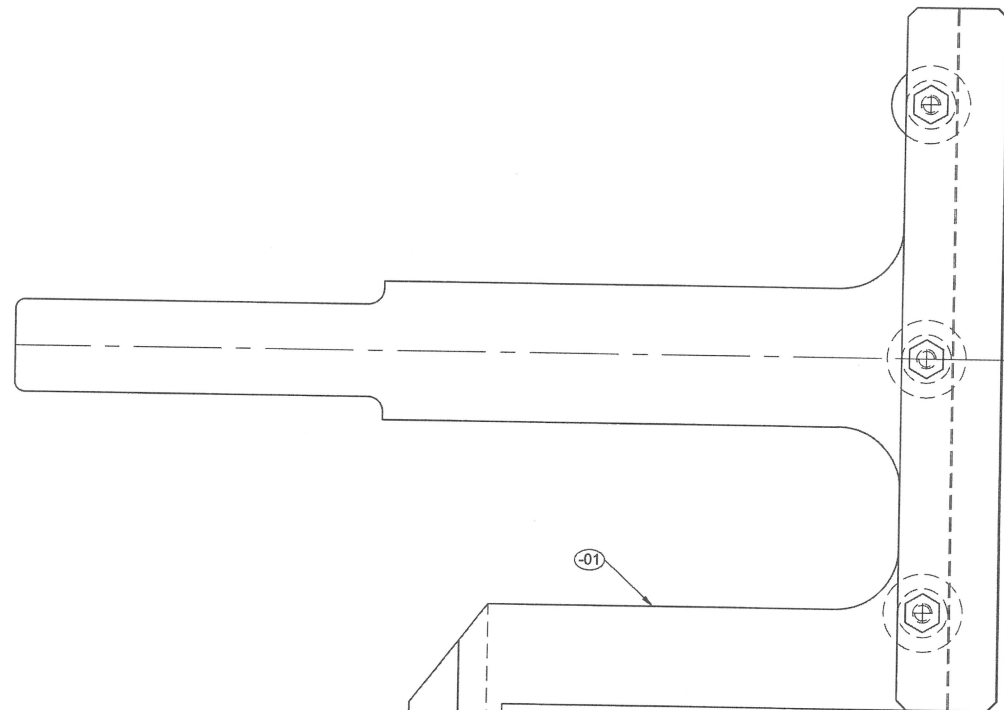
Part / Item	Component Name	Quantity	Operation	Container
6121K14	Black-Oxide Steel Knurled Grip Knob with 1/4"-28 Threaded Hole, 1" Head Dia.	3 (3 ea)	110-Small Fab - 1	
AN4-7A	Bolt	3 Ea (3 ea)	110-Small Fab - 1	
RBW895-3101-04-145-01 Handle		1 pcs (1 ea)	110-Small Fab - 1	
RBW895-3101-04-145-03 Clamp		1 pcs (1 ea)	110-Small Fab - 1	

Job Allocations

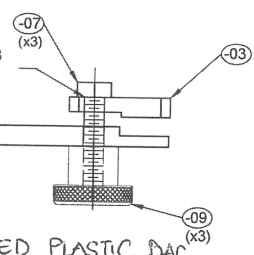
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	6121K14	3	0	0
	AN4-7A	3	127	0
	RBW895-3101-04-145-01	1	0	0
	RBW895-3101-04-145-03	1	0	0

Part Specifications
Specifications could not be found.

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APPLY LOCTITE 262
BETWEEN SURFACE
OF ITEM -07 AND ITEM -03
AND REMOVE EXCESS



REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	BUBBLES UPDATED, ITEM -09 MCM# CHANGED FOR MCM# 6121K14, NOTES UPDATED		WH	WH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199269 MLS
190876

*TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

ASSY QTY	QTY	PART #	DESCRIPTION	MATERIAL	BIO INFORMATION OR SPECIFICATIONS	Pg.
		-01	HANDLE	6061	1/4 x 9-7/8 x 12-3/4	2
		-03	CLAMP	6061	1/4 x 1-3/8 x 9-1/8	2
		-07	HEX HEAD CAP SCREW	PLATED STEEL	1/4-28 UNF x 7/8 AN4-7A	1
		-09	KNURLED KNOB	STEEL	1/4-28 UNF MCMaster-CARR #6121K14	1

ECN 19-845

RED BARN MACHINE

TITLE M/R BLADE TAB BENDER

DWG NO. RBW895-3101-04-145

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES DECIMALS .005 FRACTIONS 1/32 ANGLES .5°
X .01 X .01

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 ± .005 PER .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SCALE NTS DATE 3-11-10 SHEET 1 of 2

DRAWN BY: PERRITT
APPROVED: [Signature]
USED ON MODEL
AGUSTA

HK

Nov 18/19



NCR No.

19-7724

Route update only

Job: 199269		DISPOSITION		DEPARTMENT/PROCESS			
Part No. RBW895-3101-04-145		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: 10-18-2019		Sequence #: 110		QTY Affected: 1		MRB (QSI042) DAS 51 19/10/19 9-89	
Description Work Order Deviation		Disposition		Completed By MLL			
Drill the holes at .250 to remove extra paint. Added alodine on aluminum that was showing		Acceptable Remove Extra Paint ID holes, and Alodine any inside holes. Holes are per Drawing dimension tolerance		Lead hand / Supervisor SB 19/10/28			
QC / QA Coordinator DAS 9 9-89 19/10/28		Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☒ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		Other/Details:			